

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007604**Date Inspected:** 17-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 2:

This Caltrans QA inspector monitored activities related to end and strand stiffener replacement for Partial Joint Penetration (PJP) welds exceeding Welding Procedure Specification root gap tolerance on OBG segments 1AAW and 1AAE.

1AAE

The following stiffener welds that were tested and accepted by ZPMC MT technicians were verified and accepted by QA.

A13- SEG2E-429, 387
 SEG2D-129

A21- SEG2E-355, 313
 SEG2C-148

Welding in progress- SEG2E-334, SEG2F-026, SEG2D-088 (3G & 2F FCAW)

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Joint Fit-up of stiffeners verified by ZPMC ABF and CT:

1. Weld joints SEG2E-334, SEG2F-026, SEG2D-088 located on A00
2. Weld joints SEG2E-296, 338, SEG2D-101 located on A04
3. Weld joints SEG2E-347, 305, SEG2D-130 located on A13

1AAW

The following base metal excavation repair areas that were tested and accepted by ZPMC MT technicians were verified and accepted by QA.

A41 - SEG1E-253
SEG1F-024
SEG1C-024

The following base metal excavations areas that were tested and accepted by ZPMC MT technicians were verified and accepted by QA.

A40- SEG1E-164, 254
SEG1C-026

FCAW welding of weld joint SEG1E-1000 internal stiffener weld. ZPMC welder was identified as 058245. ZPMC QC is identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2232-TC-U4b-F-2.

Bay 3-

This QA Inspector observed the following work in progress: SAW welding of weld joint 001 located on CB202E-010. ZPMC welder was identified as 050502. ZPMC QC is identified as Liu Wei Wei. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-B-L2C-S-2.

FCAW welding of weld joint 045 located on Floor beam, FB010-038. ZPMC welder was identified as 066746. ZPMC QC is identified as Liu Wei Wei. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2232-TC-U4b-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
